

Work Order ID 106791

September-30-13 11:19:02 AM

106791

Page 1

Item ID: D350-689-041

Accept

N900040100

Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Dual High Back Seat Assembly

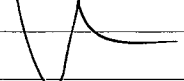
Start Date: 9/11/13 Start Qty: 1.00 ***1***

Cust Item ID:

Required Date: 9/11/13 Req'd Qty: 1.00 ***1***

Customer:

Reference:

Approvals: Process Plan:  Date: _____ Tooling: _____ Date: _____
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start ***NR1***

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D3022	B								
D3023	A								
IIN D350-689	B								

100

0.00

100

Large Fab

Brake NC

Memo

0.00

Brake NC

1-Bend D3023-1 form edge of back pan as per dwg D3023 using D3017-041
back frame
2- Bend D3022-1 as per dwg

  13-10-8

110

QC5- Inspect part completeness to step on W/O

0.00


110

QC

Memo

0.00

Quality Control

13-10-08 

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Item ID: D350-689-041

Accept

N900040100

Setup Start *NS1*

Revision ID:

Stop *NS2*

Item Name: Dual High Back Seat Assembly

Start Date: 9/11/13 Start Qty: 1.00

1

Cust Item ID:

Required Date: 9/11/13 Req'd Qty: 1.00

1

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____


QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start *NR1*

Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
114		0.00							
114									
Large Fab	Memo	0.00							
Large Fab	1- Transfer drill Seat Pan From Frame ***Transfer drill in D3022-1 using D3017-041***								
	2- Deburr								
	3- Assemble as per IIN 350-689-041								
116	QC5- Inspect part completeness to step on W/O	0.00							
116									
QC	Memo	0.00							
Quality Control									
117	Chemical Conversion Coat per QSI005 4.1	0.00							
117									
HandFinish	Memo	0.00							
Hand Finishing	Chemical Conversion Coat only D3023-1 and D3022-1								

D E 13-10-8

13-10-08 

1 70 13-10-9

Work Order ID 106791

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September-30-13 11:19:02 AM

Item ID: D350-689-041 Accept *N900040100* Setup Start *NS1*
 Revision ID: Stop *NS2*
 Item Name: Dual High Back Seat Assembly
 Start Date: 9/11/13 Start Qty: 1.00 *1* Cust Item ID:
 Required Date: 9/11/13 Req'd Qty: 1.00 *1* Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start *NR1*
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
118		0.00							
118						IX			13/10/10
Small Fab	Memo	0.00							
Small Fab	Assemble back panel to back frame as per dwg								
119	QC5- Inspect part completeness to step on W/O	0.00				J			
119									
QC	Memo	0.00							
Quality Control									
120	Grey Sandtex(Ref:4.3.5.6) per QSI005 4.3	0.00							
120									
Powdercoat	Memo	0.00							
Powder Coating	Powder coat								
	START TIME: 11:00								
	OVEN TEMPERATURE: 320°F								
	FINISH TIME: 11:30								

M125028

IX JAM 13/10/10

106791

September-30-13 11:19:02 AM

N900040100

Setup Start *NS1*

Stop *NS2*

*** 1 ***

Start Date: 9/11/13 **Start Qty:** 1.00

Cust Item ID:

Required Date: 9/11/13 **Req'd Qty:** 1.00

* 1 *

Customer:

Reference:

Run Start *NR1*

Approvals: _____ **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____

Stop *NR2*

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

[illegible]

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Item ID: D350-689-041

Accept

N900040100

Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Dual High Back Seat Assembly

Start Date: 9/11/13 Start Qty: 1.00 ***1***

Cust Item ID:

Required Date: 9/11/13 Req'd Qty: 1.00 ***1***

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start ***NR1***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
160	Identify as per dwg & Stock Location: _____	0.00			6				
160					9-89				
Packaging	Memo	0.00							
Packaging									
170	QC21- Final Inspection - Work Order Release	0.00							
170									
QC	Memo	0.00							
Quality Control									

PP 106769

13/10/22

MLJ 13-10-23

13-10-22

Picklist Print

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Page 1

Work Order ID: 106791

Parent Item: D350-689-041

Start Date: 9/11/13

Required Date: 9/11/13

Parent Item Name: Dual High Back Seat Assembly

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP Rev:H Removed Sub-Parts 06-02-09 JLM
 IPP Rev:I As per NCR 070 06-09-06 JLM
 10.02.12 verified by:JLM
 IPP Rev:J as per DSI 9498 DD

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
AN3-12A Bolt		Purchased	No			140	Each	185.0000	3	3			DAS 26 9-89

Location	Loc Qty	Loc Code
GA	6	
122407	6	
ST351	179	
114536	1	
123352	2	
m125709	100	
m125752	2	
m126192	74	

AN960JD10L Washer	NAS1149D0332J	Purchased	No			140	Each	0.0000	17	3x 17			DAS 26 9-89
D3016-041 Seat Frame Assembly		Manufactured	No	107274x1		114	Each	0.0000	1	EL 13-10-8			
D3017-041 Seat Back		Manufactured	No	B105520 x1		114	Each	0.0000	1	EL 13-10-8			
D3021-041 Tube Assembly		Manufactured	No	B105546 x1		140	Each	0.0000	1	EL 13-10-8			
D3022-1 Seat Pan		Manufactured	No			100	Each	2.0000	1	EL 13-10-8			

Location	Loc Qty	Loc Code
107374x1 WA001	2	
101074	2	

D3023-1 Back Panel		Manufactured	No	104932x1		100	Each	0.0000	1	EL 13-10-8			
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Work Order ID: 106791

Parent Item: D350-689-041

Parent Item Name: Dual High Back Seat Assembly

Start Date: 9/11/13

Required Date: 9/11/13

Start Qty: 1.00

Required Qty: 1.00

D3024-1	Manufactured	No	140	Each	28.0000	3	3	DAS 26 9-89
Spacer								

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
ST024	28	
104966	24	
95346	4	

3x

D3028-1	Manufactured	No	140	Each	16.0000	4	4	DAS 26 9-89
Stud								

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
ST024	16	
97695	16	

4x

X

D3029-1	Manufactured	No	140	Each	14.0000	2	2	DAS 26 9-89
Spring								

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
GA	14	
105583	10	
68607	1	
90659	3	

2

DAS
36
9-89

D3030-1	Manufactured	No	140	Each	10.0000	2	2	DAS 26 9-89
Lock								

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
ST024	10	
97713	10	

2x

D3031-1	Manufactured	No	140	Each	15.0000	2	2	13-10-10
Loop								

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
GA	3	
79747	3	
ST024	12	
97679	12	

2x

DAS
26
9-89

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Work Order ID: 106791

Parent Item: D350-689-041

Parent Item Name: Dual High Back Seat Assembly

Start Date: 9/11/13

Required Date: 9/11/13

Start Qty: 1.00

Required Qty: 1.00

MS20600-AD4W2 Purchased No

118 Each 2,258.0000 40

40

PS 13/10/10

Location

Loc Qty

Loc Code

ST311	600	
m125708	600	
ST506	658	
125578	658	
ST554	1000	
m126475	1000	

DAS
36
9-89

MS20600-AD4W3 Purchased No

118 Each 721.0000 6

6

PS 13/10/10

Location

Loc Qty

Loc Code

ST311	588	
122151	4	
122452	4	
123525 -	288	
124231	292	
WA003	133	
107939	133	

DAS
36
9-89

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Work Order ID: 106791

Parent Item: D350-689-041

Parent Item Name: Dual High Back Seat Assembly

Start Date: 9/11/13

Required Date: 9/11/13

Start Qty: 1.00

Required Qty: 1.00

MS21042L3

Purchased

No

140

Each

5,740.0000

17

17

DAS
26
9-89

Nut

13-10-10

Location

Loc Qty

Loc Code

FP001

3

122141

3

GA

18

122452

18

ST314

304

111668

1

117885

32

119017

55

119075

138

123265

43

M126036

35

ST506

1177

123900

856

124291

321

ST510a

4238

M126275

238

M126333

4000

M7V

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Work Order ID: 106791

Parent Item: D350-689-041

Parent Item Name: Dual High Back Seat Assembly

Start Date: 9/11/13

Required Date: 9/11/13

Start Qty: 1.00

Required Qty: 1.00

MS21042L4 Purchased No

140 Each 3,402.0000 6 6

DAS
26
9-89

Location	Loc Qty	Loc Code
FP001	50	
122452	38	
8182	12	
ST314	9	
m125708	9	
st507	33	
m126073	33	
ST509	2887	
m126275	2887	
ST510a	258	
m126333	258	
ST518	165	
124231	165	

Cox

MS24693-S272 Purchased No

140 Each 449.0000 4 4

DAS
26
9-89

Location	Loc Qty	Loc Code
ST301	97	
124704	5	
M126119	92	
st507	352	
M126190	352	

4X

MS27039-1-17 Purchased No

140 Each 203.0000 4 4

DAS
26
9-89

13-10-10

Location	Loc Qty	Loc Code
GA	48	
120142	48	
ST506	155	
124326	155	

4X

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Work Order ID: 106791

Parent Item: D350-689-041

Parent Item Name: Dual High Back Seat Assembly

Start Date: 9/11/13

Required Date: 9/11/13

Start Qty: 1.00

Required Qty: 1.00

MS27039-1-19	Purchased	No	140	Each	1,266.0000	6	6	DAS 26 9-89
Screw								

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
-----------------	----------------	-----------------

ST306	102	
122814	2	
123522	100	
ST504	1000	
125654	1000	
ST506	164	
124326	164	

MS27039-4-21	Purchased	No	140	Each	59.0000	6	6	DAS 26 9-89
Screw								

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
-----------------	----------------	-----------------

ST307	59	
124586	9	
m126319	50	

NAS1149D0432J	Purchased	No	140	Each	472.0000	6	6	DAS 26 9-89
WASHER								

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
-----------------	----------------	-----------------

GA	1	
116583	1	
ST293	52	
124580	52	
ST294	3	
116583	3	
ST510a	416	
125578	416	

September-30-13 11:19:01 AM

Shop Packet Print

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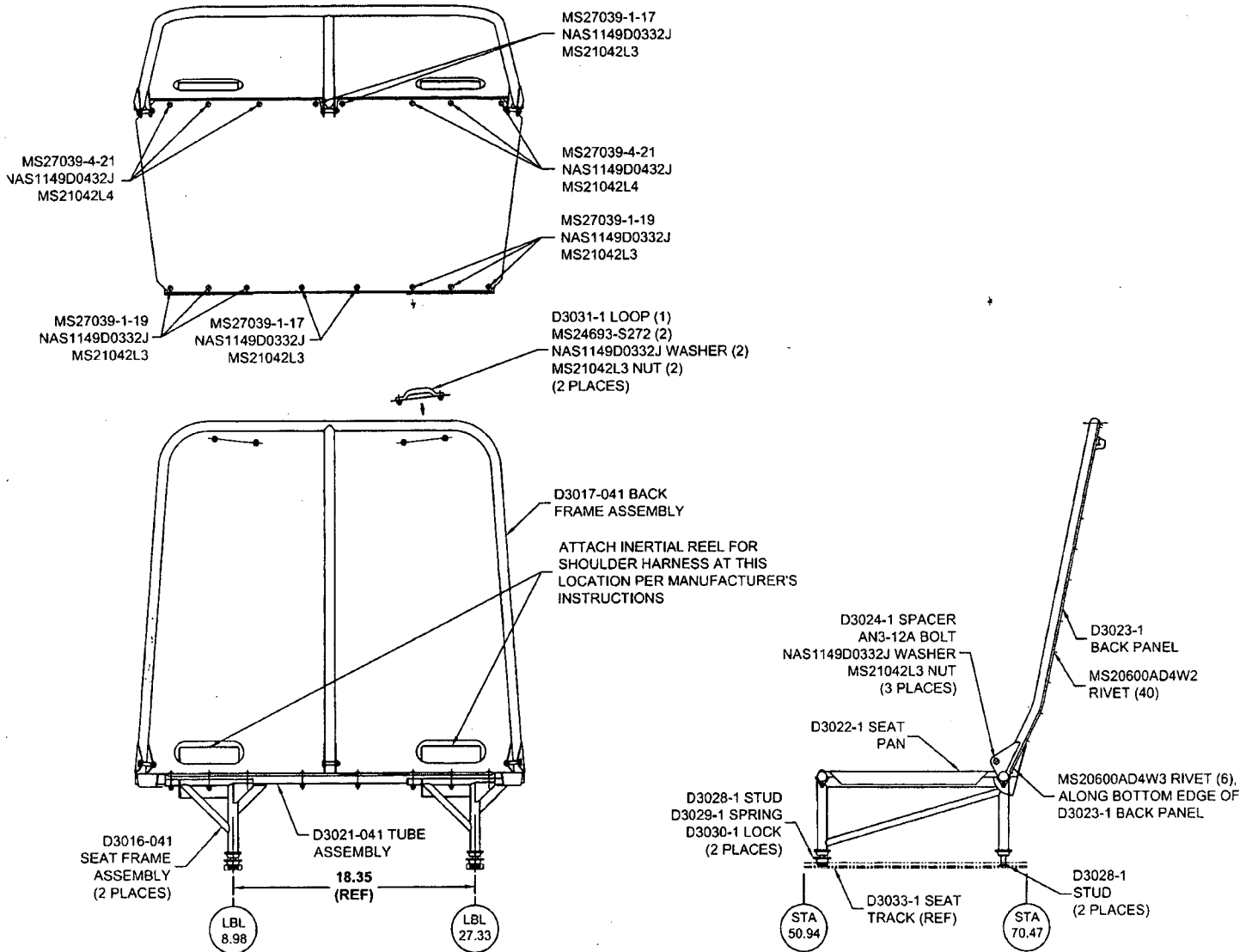


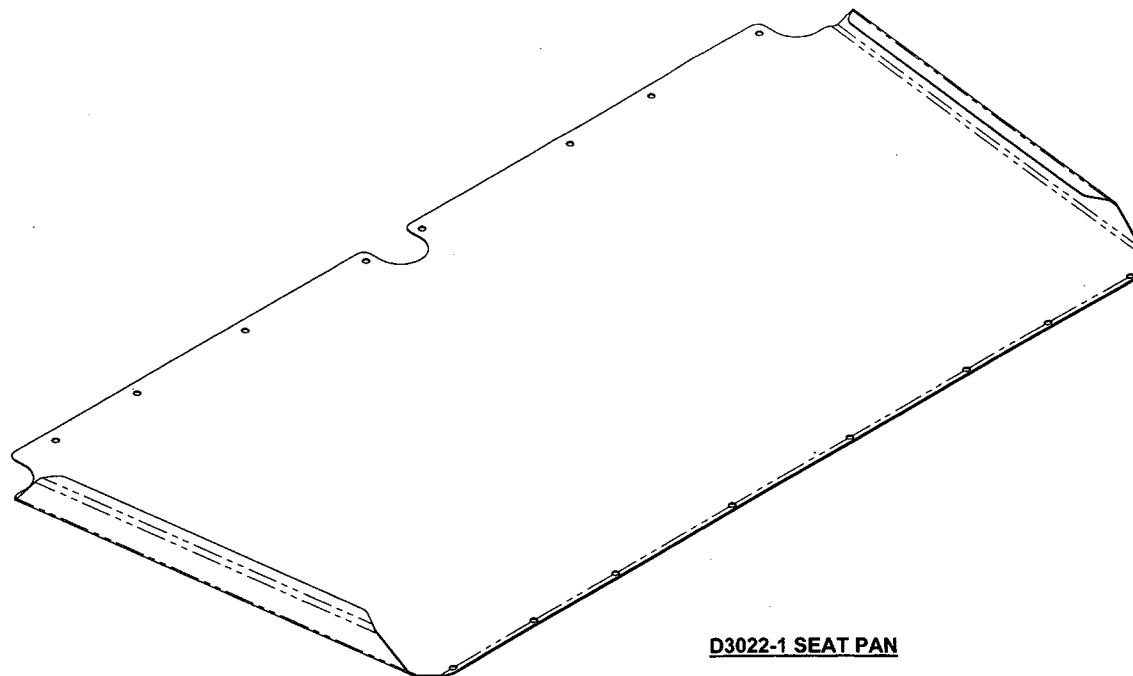
FIGURE 9: Installation of D350-689-041 Dual High Back Seat Assembly

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Revision: **B**

Date: 11.07.22

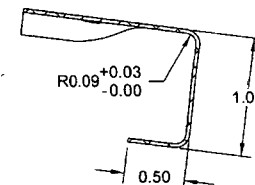
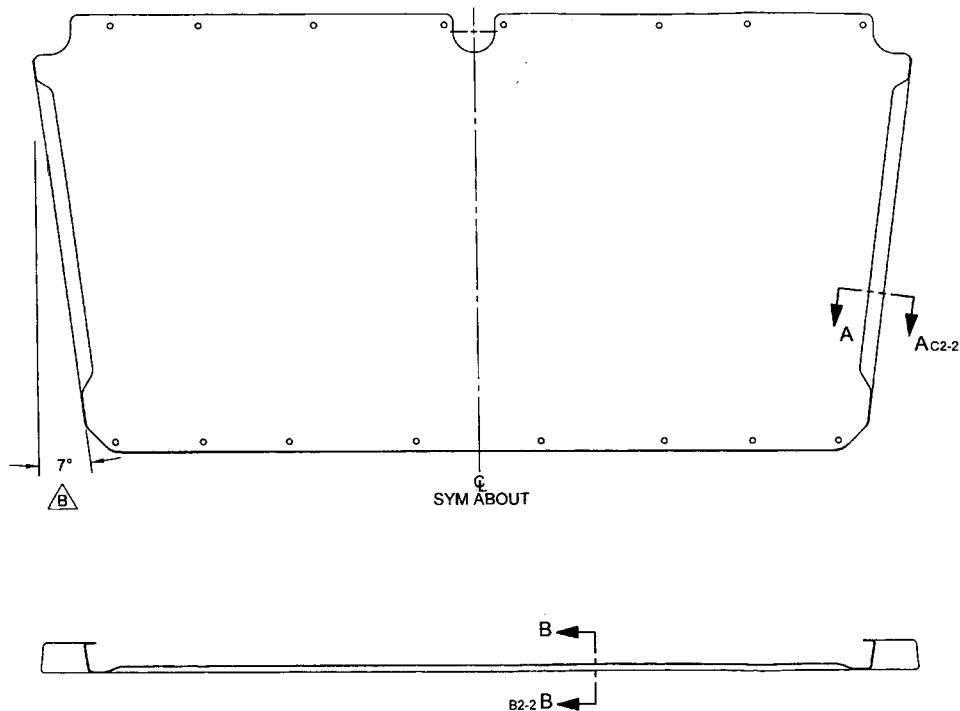


D3022-1 SEAT PAN

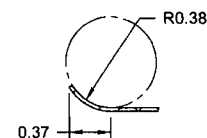
RELEASED
06/12/15 W

w/o 106794

B	REDRAWN IN SOLIDWORKS TO CURRENT DESIGN STANDARDS AND TRANSFERRED TO "B" SIZE BORDER. SPLIT VIEWS FOR FORMED PART AND FLAT PATTERN. BT-2 7" DIM ADDED. D7-3 12.075 WAS 12.325. D5-3 9.175 WAS 9.425 & D5-3 5.300 WAS 5.550. REASON: DRAFTING ERROR.	AJS	08.11.27
A	NEW ISSUE	CP	01.05.18
REV.	DESCRIPTION	BY	DATE
DESIGN	CP	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA DRAWING NO. D3022 REV. B SHEET 1 OF 3 TITLE SEAT PAN SCALE NTS DATE 08.11.27	
DRAWN	AJS		
CHECKED			
MFG. APPR.			
APPROVED			
DE APPR.		COPYRIGHT © 2001 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	



SECTION A-A C4-2
SCALE 4X



SECTION B-B A6-2
SCALE 4X

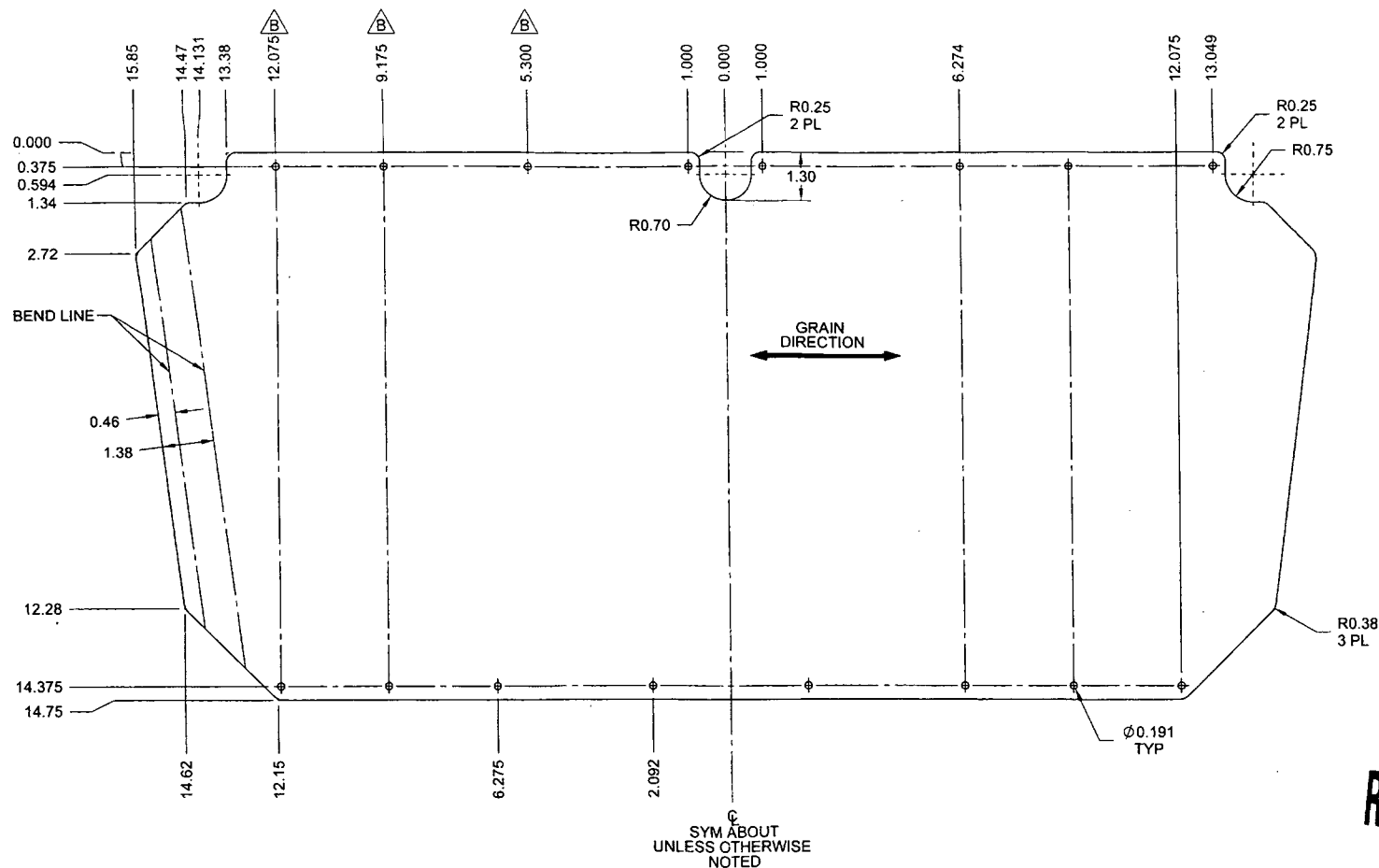
D3022-1 SEAT PAN B

RELEASED
08/12/15

NOTES:

- 1) MATERIAL: MAKE FROM D3022-1F
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT GREY SANDTEX (4.3.5.6) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3022-1" USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: 1.36 lbs

DESIGN	CP	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	AJS		
CHECKED		DRAWING NO.	REV. B
MFG. APPR.		D3022	SHEET 2 OF 3
APPROVED		TITLE	SCALE
DE APPR.		SEAT PAN	NTS
DATE	08.11.27	<small> COPYRIGHT © 2001 BY DART AEROSPACE LTD. THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD. </small>	



NOTES:

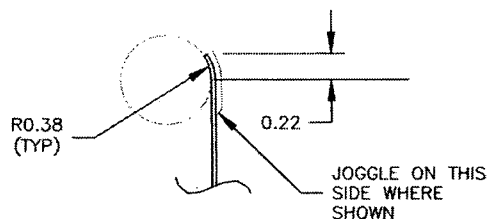
- 1) MATERIAL: 2024-T3 ALUMINUM SHEET, 0.032 THICK
PER AMS-QQ-A-250/4 OR AMS 4037
REF DART SPEC M2024T3S.032
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 1.36 lbs

D3022-1F SEAT PAN B

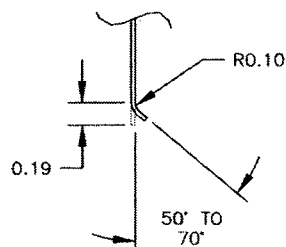
DESIGN	CP	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	AJS		
CHECKED		DRAWING NO.	REV. B
MFG. APPR.		D3022	SHEET 3 OF 3
APPROVED		TITLE	SCALE
DE APPR.		SEAT PAN	NTS
DATE	08.11.27	<small>COPYRIGHT © 2001 BY DART AEROSPACE LTD THIS DOCUMENT IS UNCLASSIFIED AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	

RELEASED
08/12/15 JAW

SECTION A-A
SCALE 1:1
(TYPICAL, EXCEPT WHERE SHOWN)

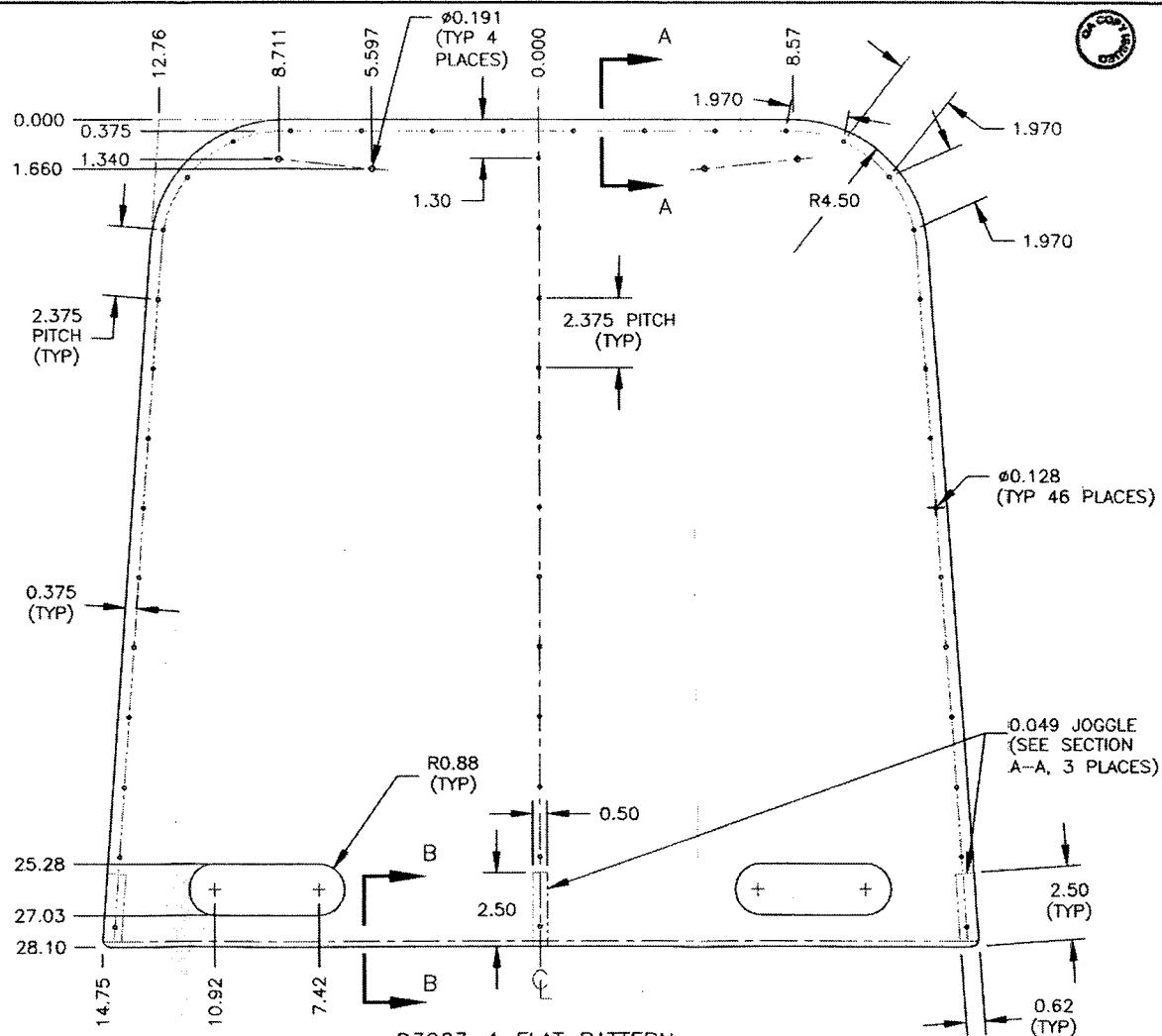


SECTION B-B
SCALE 1:1
(BOTTOM EDGE ONLY)



RELEASED
9.06.07

D3023-1 BEND DETAIL



D3023-1 FLAT PATTERN

D3023-1 BACK PANEL:

- 1) MATERIAL: 2024-T3 (QQ-A-250/4) 0.032 THICK
- 2) FINISH: ACID ETCH & ALODINE PER DART QSI 005 4.1
POWDER COAT GREY SANDTEX (REF 4.3.5.6) PER DART QSI 005 4.3
- 3) ALL DIMENSIONS ARE IN INCHES.
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.

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A		01.05.18	NEW ISSUE	
DESIGN	UP	DRAWN BY	UP	DART AEROSPACE LTD. HARRISBURY, ONTARIO, CANADA
CHECKED	#	APPROVED	#	DRAWING NO. D3023
DATE	01.05.18	TITLE	BACK PANEL	REV. A SHEET 1 OF 1 SCALE 1:4